

*Blue*  
**Work Order ID 62622**

October 5, 2010 11:51:13 AM



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: *10-10-05* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

*N/A [Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng & Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

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Stop



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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110



Skidtubes

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod ☒ *m11385/m115778*

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 *Drill Bit*

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

*1* *—* *BE 10/10/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: D206-642-441

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Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
116  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00							
120  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							

8/10/10/14

8/10/10/14

DP

(H)

10-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 - BE 10/10/19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 62622

October 5, 2010 11:51:24 AM



Page 5

Item ID: D206-642-441

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail  
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.  
cure time before cutting

Start Date: 10/10/20

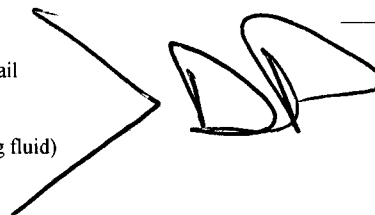
Time: 4:00

Finish Date: 10-10-21

Time: 12

A/R Sikaflex-291

Sikaflex expiry date: 11/01/01



10-10-19

BB 10/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

## [REDACTED]

Page 6

**Accept**

[illegible]**Setup Start**

**Stop**

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

**Stop**

## Operation Description

## Set Up/ Run Hours

**Tool ID****Tool #**

## Plan Code

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stam**

150

QC5- Inspect part completeness to step on W/O

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

160

0.00



## Skidtubes

## Skidtubes

## Memo

0.00

## Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod ☐ *m11305*

2-Grind welds flush as per Dwg D2650.

3-Counterbore 5/16" x 0.750" deen as per Dwg D2650 Deburr

BE 10/10/25

DP

10-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 62622

October 5, 2010 11:51:30 AM



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Item ID: D206-642-441

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Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0.00



HandFinishing

Skidtubes

Memo

0.00

Skidtubes

Install D2680-041 Nut Plate as per Dwg D2650

DP

10-10-26

180

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

8/10/10/26

40

190

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/10/26

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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October 5, 2010 11:51:30 AM



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Item Name: Replacement Skidtube

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Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

Pressure Wash per QSI005 4.3

0.00

⇒ H 10/10/22



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

211

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 115967  
PAINT DELFLEET BLUE B 115509  
CLEAR DELFLEET B 115949

MA 10 11 03 (1)

221

0.00



QC

QC14- Inspet Spray Paint

Memo

0.00

Quality Control

MA 10-11-04 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 62622

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Item ID: D206-642-441

Accept



Setup Start



Revision ID:

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Item Name: Replacement Skidtube

Start Date: 10/05/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/22/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

0.00

⇒ JH

10/11/08

1

Ø



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

✓ A/R ☐ Sikaflex-291 ☐ 1111409 ☐  
Sikaflex expiry date: ☐ 10/10

✓ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

✓ 3-Install MS27039-4-06 Screw as per DEO 9153

✓ 4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ 1111409 ☐  
Sikaflex expiry date: ☐ 10/10

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: 11115790

*[Signature]*

**Dart Aerospace Ltd**

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**Work Order ID 62622**

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10/11/09 1

250



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D206-642-441

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

0.00

0.00

PP

62613

10/11/09

260



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/09 MF 10-11-9

# Picklist Print

October 5, 2010 11:51:02 AM

Page 1  
4

Work Order ID: 62622



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM  
 IPP Rev:I 08-05-01 add QC3 DD verified by:EC  
 IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K  
 10.09.27 SS washers for wearplates EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			230	Each	1,214.000	60	60			
Insert													

Location Loc Qty Loc Code

PKG11 1165

114723 1165

ST282 10

110511 10

ST381 39

114654 39

AN960JD10L NAS1149D0332J Purchased No



Washer

230 Each 0.0000 2

1114884



12 10/11/08

AN960JD416 NAS1149D0463J Purchased No



Washer

230 Each 24.0000 1



1 10/11/08

Location Loc Qty Loc Code

ST300

113288

24

1115622

1

**Dart Aerospace Ltd**

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# Picklist Print

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1/8

Work Order ID: 62622



Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased

No

170

Each

446.0000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

446

112314

4

113539

44

113973

398

CR3212-4-03

Purchased

No

230

Each

1,888.000

2

2



Cherry Rivet



Location

Loc Qty

Loc Code

ST311

1888

111359

5

112314

2

114436

448

114450

71

114859

1362

D2620

Manufactured

No

110

Each

8.0000

1

1



Skidtube, 206 Skidtube



Location

Loc Qty

Loc Code

LG

8

61632

8

*[Signature]*

*[Signature]*

*[Signature]*

DP 10-10-26  
B/E 10/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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October 5, 2010 11:51:02 AM

Page 3

Work Order ID: 62622

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

110

Each

50.0000

1

1



Aft Cap

blue

Location

Loc Qty

Loc Code

FP-4

45

57332

45

fp5

1

61752

1

FP6

4

52663

4

B62652

x1

D2647

Manufactured No

140

Each

66.0000

1

1



Cap

Location

Loc Qty

Loc Code

FP

66

55352

66

1 BE 10/10/12

D2649

Manufactured No

170

Each

65.0000

23

23



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

65

58545

2

60652

4

61496

59

B 62889

23

BB 10/10/25

October 5, 2010 11:51:02 AM

Shop Packet Print

Page 3



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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October 5, 2010 11:51:03 AM

Page 4  
4

Work Order ID: 62622

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D2651-1

Manufactured No

230

Each

622.0000

22

22



Plug

blue

Location

Loc Qty

Loc Code

FP

252

B 62638

x2

51530

152

61751

100

x20

fpa

370

53349

235

57869

135

D2651-3

Manufactured No

230

Each

626.0000

22

22



O-Ring

Location

Loc Qty

Loc Code

FP

626

46114

130

61962

496

x5

x14

D2654-7

Manufactured No

160

Each

0.0000

1

1



Web

B 62686

1

B 10/10/20

D2680-041

Manufactured No

170

Each

29.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

S1021

29

55366

29

DO

10-10-26.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 5  
8

Work Order ID: 62622

Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 10/05/10



Required Date: 10/22/10

Start Qty: 1.00



Required Qty: 1.00

D3535-15	Manufactured	No	230	Each	6.0000	1	1
							<u>10/11/08</u>
Wearshoe							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	6	B62241
61241	6	

D3535-23	Manufactured	No	230	Each	19.0000	1	1
							<u>10/11/08</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	7	
61830	7	
FP021	20	
60231	11	

D3535-37	Manufactured	No	230	Each	9.0000	1	1
							<u>10/11/08</u>
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	9	
56101	9	

D3536-15	Manufactured	No	230	Each	10.0000	1	1
							<u>10/11/08</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	9	B62459
56055	1	
60875	8	
FP11	1	
59238	1	

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

October 5, 2010 11:51:05 AM

Page 6

Work Order ID: 62622

Parent Item: D206-642-441


Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

D3536-23	Manufactured	No	230	Each	8.0000	1	1
							
Gasket							

Location

Loc Qty

Loc Code


FP011

8

1363391

61237

8

D3536-37	Manufactured	No	230	Each	8.0000	1	1
							
Gasket							

Location

Loc Qty


Loc Code

FP

8

56102

8

D3537-1	Manufactured	No	230	Each	14.0000	6	6
							
Wearpad							

Location

Loc Qty

Loc Code

FP

1

55465

1

FP17

13

57713

3


1362661

60491

3

61640

7

D3537-3	Manufactured	No	230	Each	8.0000	1	1
							
Wearpad							

Location

Loc Qty

Loc Code

FP17

8

60866

8

1361674

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 7

Work Order ID: 62622

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08 Purchased No

230 Each

1,585.000

2

2



Handwritten: 10/11/10

Screw

Location

Loc Qty

Loc Code

ST291

1585

110835

473

114718

112

115108

1000

Handwritten: v2

MS27039-4-06 Purchased No

230 Each

108.0000

1

1



Handwritten: 10/11/10

Screw

Location

Loc Qty

Loc Code

ST292

108

109061

14

115460

94

Handwritten: v1

MS27039C1-08 Purchased No

230 Each

1,077.000

60

60



Handwritten: 10/11/10

SCREW

Location

Loc Qty

Loc Code

FP

276

115336

276

ST293

801

115589

800

19185

1

Handwritten: M116022

Handwritten: v60



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 8

Work Order ID: 62622

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube



Start Date: 10/05/10

Required Date: 10/22/10

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

5,239.000

60

60



HL 10/11/08

Washer

Location

Loc Qty

Loc Code

ST297

5239

113524

10

113737

150

115000

125

115698

78

115816

1276

115832

3600

X60

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOOT COPY  
UNCL SU COPY NT

NO. 42622  
BS10-10-05

RELEASED  
03-07-23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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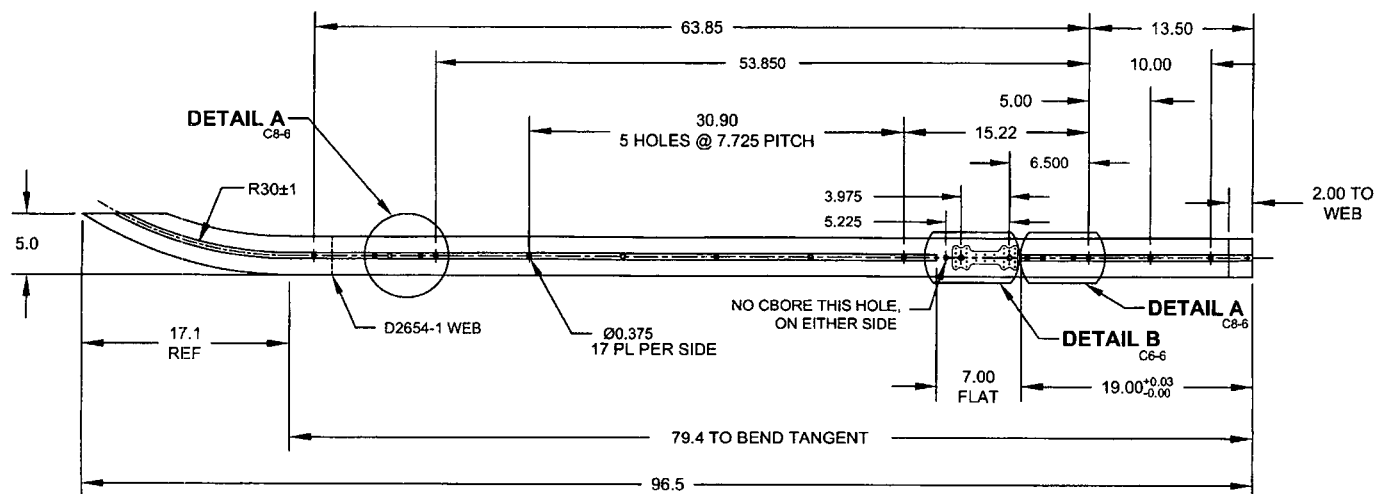
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

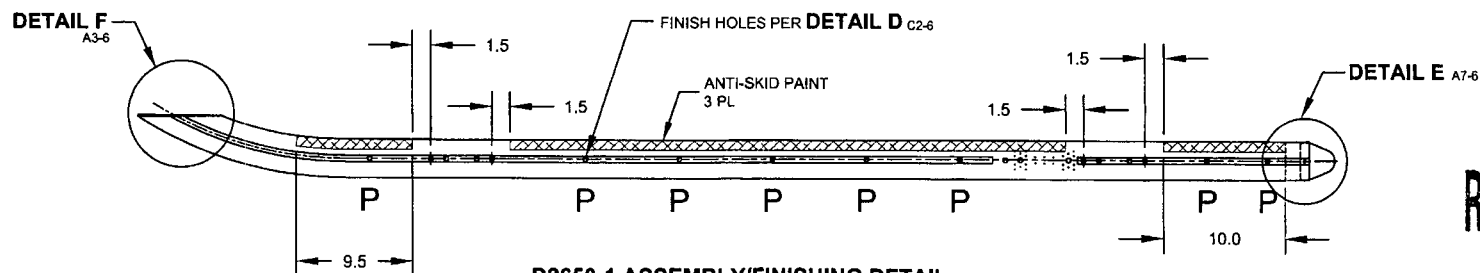
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2650-1 BENDING/DRILLING DETAIL**

*w/o 62622*



**D2650-1 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
680922/117

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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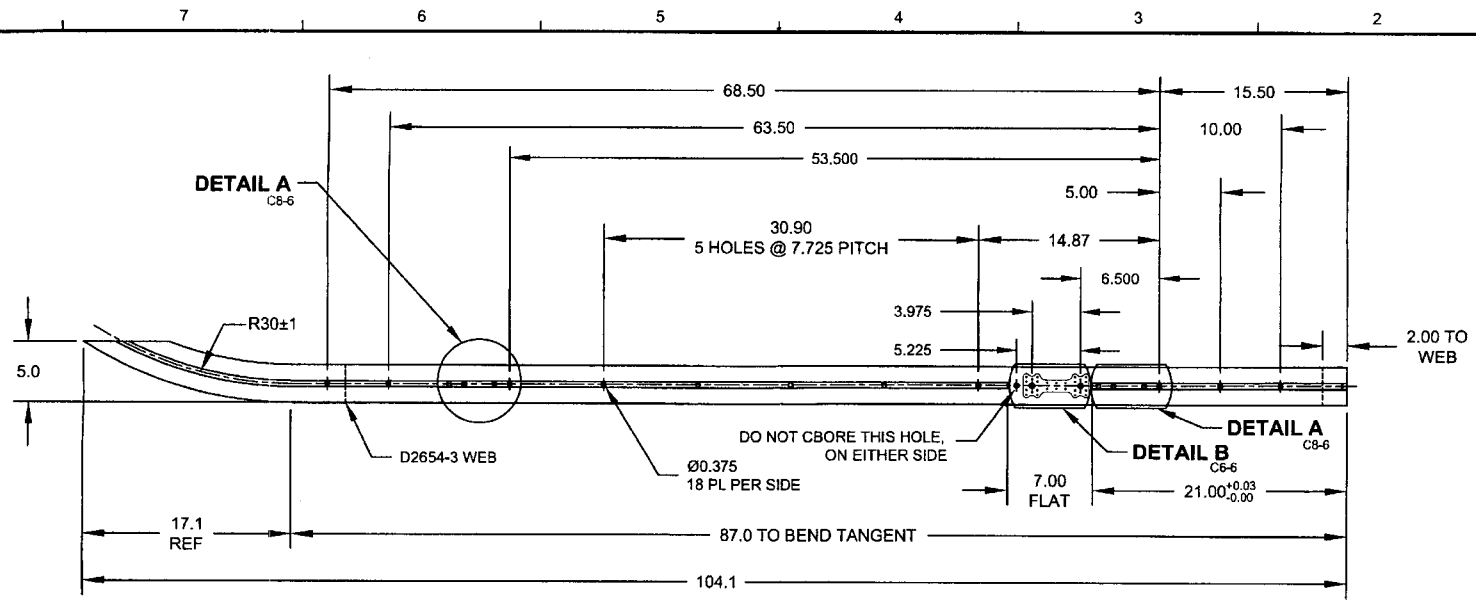
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

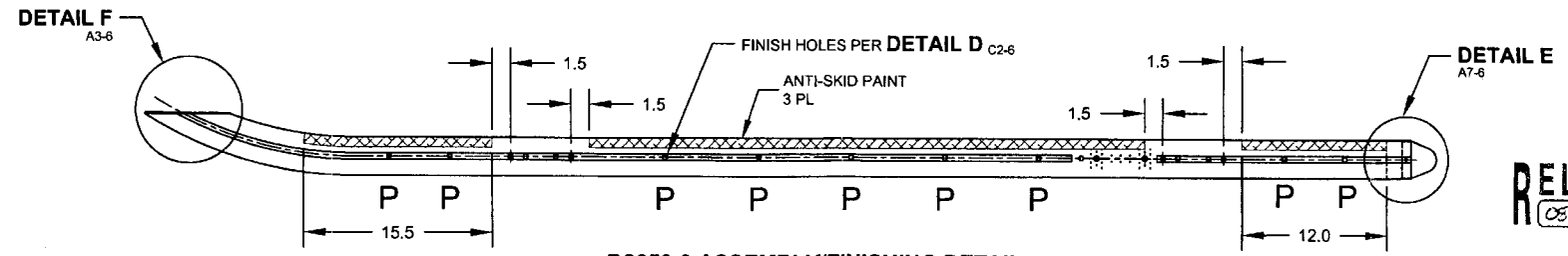
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D2650-3 BENDING/DRILLING DETAIL**

*w/o 62622*



**D2650-3 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
05-27-23

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 6
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



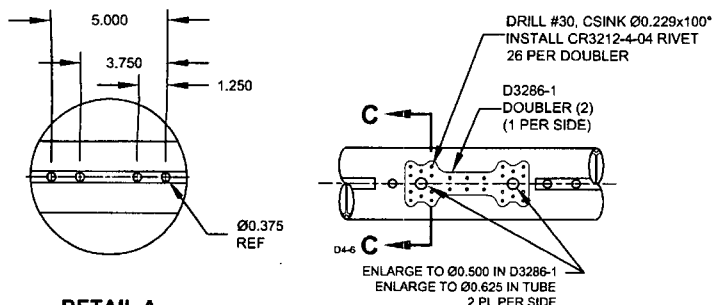
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

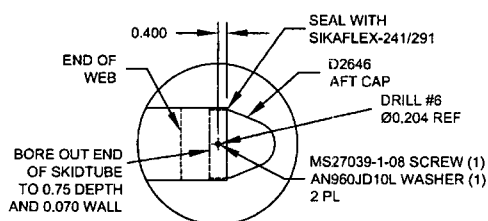
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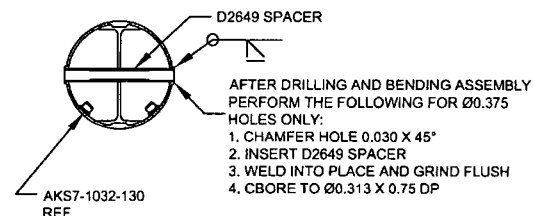
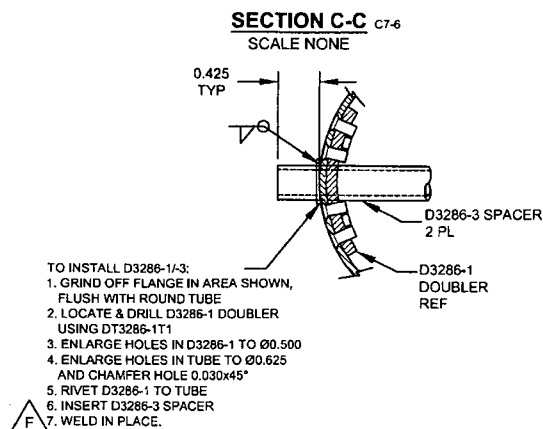


**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-6

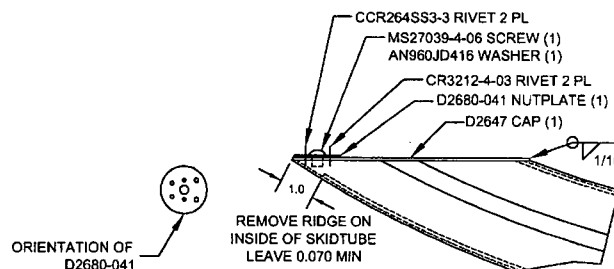
**DETAIL B**  
SCALE 2X  
C3-2  
C3-3



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

**DETAIL F NOTES:**  
1. CUT TUBE LEVEL  
2. REMOVE RIDGE ON FWD SIDE  
3. LOCATE D2647 (TRIM AS NECESSARY)  
4. WELD D2647 IN PLACE PER DART QSI 004  
5. GRIND FLUSH  
6. RIVET D2680-041 NUT PLATE IN PLACE  
NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**  
08-09-22-19

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 241

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 62280  
Part number: D206 642 541  
Description: 206 skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier D. J. D. Date of Test Coupon 10.09.30  
Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.